

Date: Thursday, 05/02/2009 3:46:23 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BUSHING
<b>Job Number</b> : 45556	
<b>Estimate Number</b> : 10503	
<b>P.O. Number</b> :	<b>Part Number</b> : D2745
<b>This Issue</b> : 05/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2745 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 44893	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 28/02/2009 <b>Qty:</b> 200 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09.02.06</u>	
<b>Comment</b> : Est C 02.03.07 Update to turn in house NG	
Est Rev:D 07-10-23 Removed tumbling JLM Verified	
By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M303R0750	303 Round Bar 0.750
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**Comment:** Qty.: 0.1007 f(s)/Unit Total : 20.1390 f(s)  
 303 ROUND .75"  
 Machine per Folio FA201 Material: AISI 303 SS

Batch: M110680

09/02/12

200 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL  
 1-Turn as per Dwg D2515  
 2-Deburr

09/02/12

200 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

09/02/12

200 pcs

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

J.L

09/02/12

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

ST

09/02/12

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 45556

Part Number: D2745

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/12 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

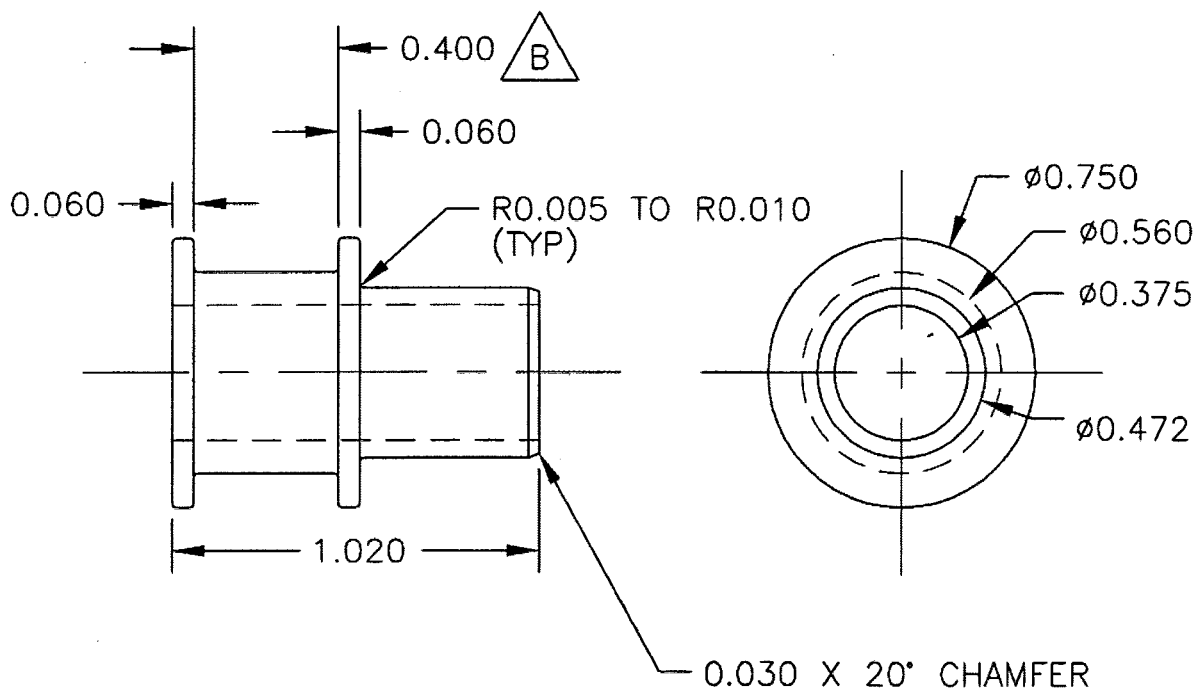
**NOTE:** Date & initial all entries





DESIGN #A	DRAWN BY CP	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED DA	APPROVED KE	DRAWING NO. D2745	REV. B SHEET 1 OF 1
DATE 98.10.23		TITLE BUSHING	SCALE 2:1
A	98.04.16	NEW ISSUE	
B	98.10.23	DIM 0.400 WAS 0.380	

RELEASED  
98.11.03 DS



MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
RADIUS ALL INSIDE EDGES 0.005 TO 0.010  
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25556